

Date: Tuesday, 3/20/2007 1:50:12 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 212/205 HIGH AFT X-TUBE ASSEMBLY
Job Number	: 31360		
Estimate Number	: 10257		
P.O. Number	:	Part Number	: D212664201
This Issue	: 3/20/2007 S.O. No. :	Drawing Number	: D212-664-241 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LANDING GEAR	Drawing Revision	: B
Previous Run	: 31359	Material	:
Written By	:	Due Date	: 4/15/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev: 04.02.16 Reformat K/DS		
	: Est Rev: F 06-03-29 Remove Coments on Pick List JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG002

2.0	D6006129	Crosstube material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6006-129 Crosstube 256106

Check OD = 3.250"; ID = 2.220"

SCURP

SF 07/04/03

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

SF 07/04/03

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

MS 07/04/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 31360

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA114

2-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

MS 07/04/14

1

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 07/04/14

1

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 07/04/15

1

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Remove sand and plugs

2-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241

MS 07/04/15

1

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

EL 7-4-16

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP

7-4-16

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of machining

EL 7-4-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 31360

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*JP 7-4-20*

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-241 using CNC bender program 212-af and Folio FT007

*EL 7-4-23*

14.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

*JP 7-4-25*

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

*RT 07-04-26  
JD 7-4-30*

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

*JD 7-4-30*

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*JP 7-4-24*  
*Found this one*

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*JP 7-4-24*

19.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 3825

LPI as per ASTM 1417 Level 2

*JP 7-4-24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 31360

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

Attach copy of NDT results to work order

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

*C-2/5/31 (1)*

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: DIMENSIONAL CHECK

Inspect for damage & ensure results are as per Dwg D212-664-241

*(PTC)*

22.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

*Scrap*

23.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

24.0

D2856600

Abrasion Strip



Comment: Qty.: 0.8400 f(s)/Unit Total : 0.8400 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600-1009 Abrasion Strip

25.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2940-1 Support

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D212-664-201 PAR #:          Fault Category:          NCR: Yes No DQA:    Date: 07.07.20  
B31360 QA: N/C Closed:          Date:         

NCR: <u>189</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>070719</u>	<u>19.0</u>	<u>Tube did not pass UDT at North Air.</u>	<u>[Signature]</u> <u>07/07/19</u>	<u>Do not use ground affected part see NCR 189</u> <u>Tube are scrap: for engineering use only. →</u>	<u>[Signature]</u> <u>070719</u>	<u>[Signature]</u> <u>070719</u>	<u>[Signature]</u> <u>07/07/19</u>	<u>[Signature]</u> <u>070719</u>

NOTE: Date & initial all entries



Date: Tuesday, 3/20/2007 1:50:13 PM  
User: Kim Johnston

## Process Sheet

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Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 31360

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp

27.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8582

2-Install supports and clamps as per Dwg D212-664-241. Torque clamps to 80-100 in lb.

*Scrap*

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

30.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: \_\_\_\_\_

31.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: \_\_\_\_\_

32.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

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Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 31360

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: \_\_\_\_\_

34.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: \_\_\_\_\_

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-201

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



✓ 07.07.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	31360
<b>Description:</b> Crosstube Assembly (205/212 High Aft)	<b>Part Number:</b>	D212-664-241
<b>Inspection Dwg:</b> D212-664-241 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

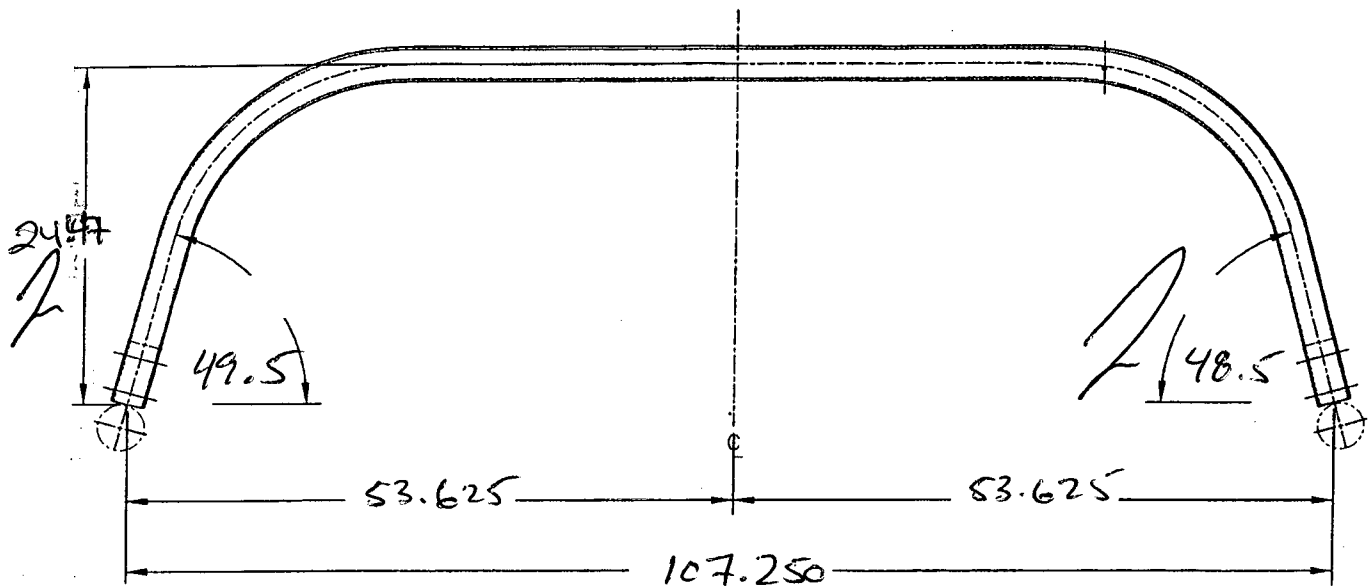
Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	2.00	✓		
	R0.063	+/-0.010	.063	✓		
	2.990	+0.005/-0.000	2.994	✓		
	5.237	+/-0.030	5.240	✓		
	2.600	+0.005/-0.000	2.604	✓		
	2.686	+0.005/-0.000	2.690	✓		
	2.770	+0.005/-0.000	2.773	✓		
	2.854	+0.005/-0.000	2.858	✓		
	2.938	+0.005/-0.000	2.941	✓		
	3.021	+0.005/-0.000	3.025	✓		
	3.133	+0.005/-0.000	3.137	✓		
	3.179	+0.005/-0.000	3.183	✓		
SIDE B	0.200	+/-0.010	2.00	✓		
	R0.063	+/-0.010	.063	✓		
	2.990	+0.005/-0.000	2.994	✓		
	5.237	+/-0.030	5.240	✓		
	2.600	+0.005/-0.000	2.603	✓		
	2.686	+0.005/-0.000	2.690	✓		
	2.770	+0.005/-0.000	2.774	✓		
	2.854	+0.005/-0.000	2.858	✓		
	2.938	+0.005/-0.000	2.941	✓		
	3.021	+0.005/-0.000	3.025	✓		
	3.133	+0.005/-0.000	3.137	✓		
	3.179	+0.005/-0.000	3.183	✓		
	124.36	+/-0.020	124.7	✓		

<b>Measured by:</b> J.F./MS	<b>Audited by:</b> GML	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/04/13	<b>Date:</b> 07/04/15	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	

DART AEROSPACE LTD		Work Order:	31360
Description: Crosstube High Aft (205/212)		Part Number:	D212-664-201
Inspection Dwg: D212-664-241 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	24.24	24.36
1/2 Span	53.66	53.78
Angle	49	52
Total Span	107.32	107.56



Comments
Acceptable by attached e-mail

QC15 Inspection	2 QS1042
Date	0704-25

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>



DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D212-664-241	REV. B SHEET 1 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (205/212 HI AFT) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED  
05.06.09 [Signature]

PH 07.03.20  
**UNDER REVIEW**  
07.03.03 PH  
revise to add  
mugband and cushion

Qty	Part Number	Description
X	D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
1	D6006-129	CROSSTUBE
2	D2940-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP

#### GENERAL NOTES:

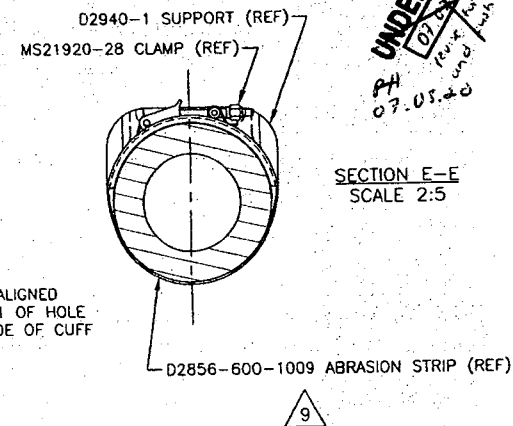
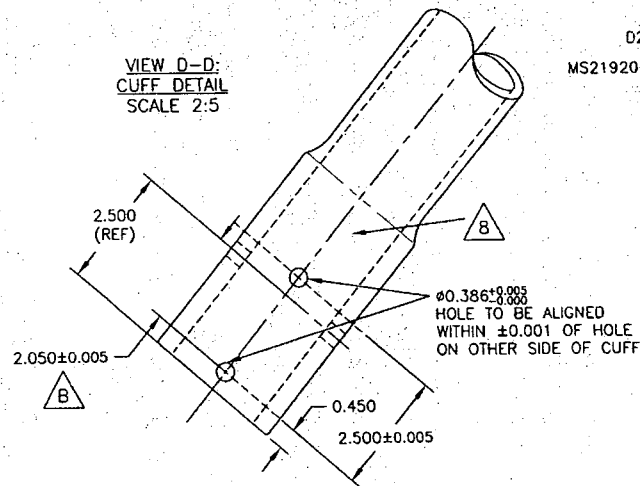
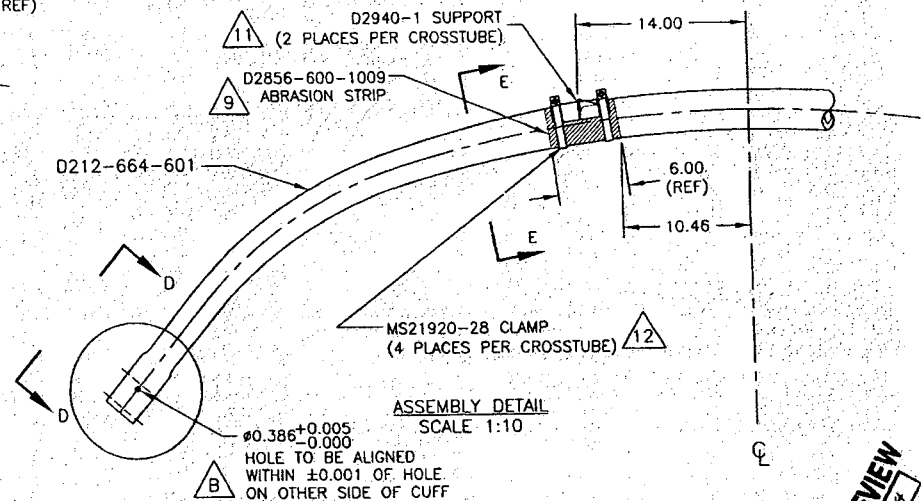
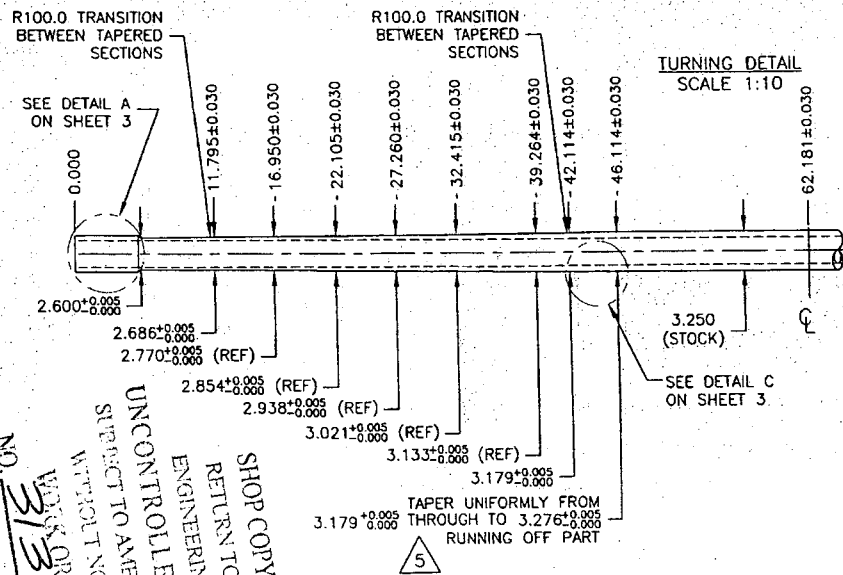
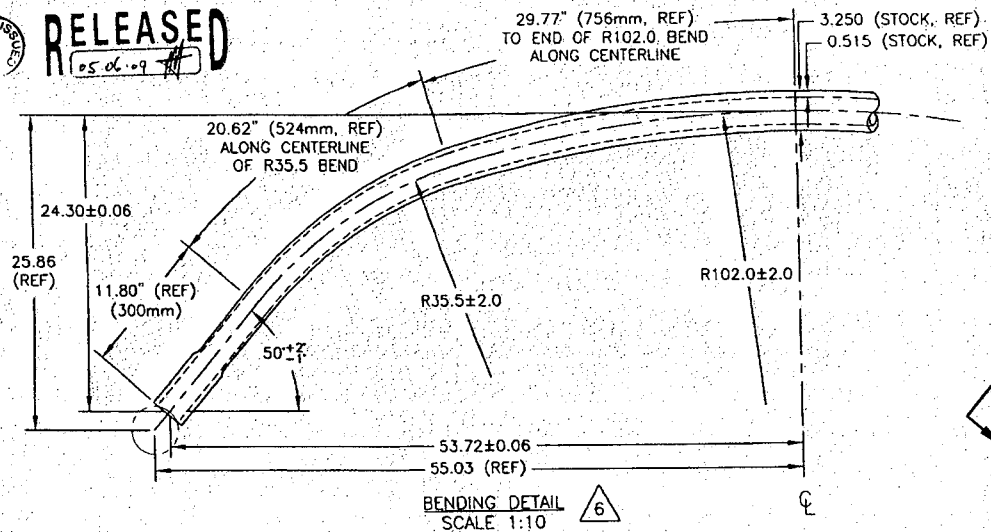
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129  
FINISHED LENGTH = 124.36±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2940-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31360

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RELEASED  
05.06.09



UNDER REVIEW  
07.05.06

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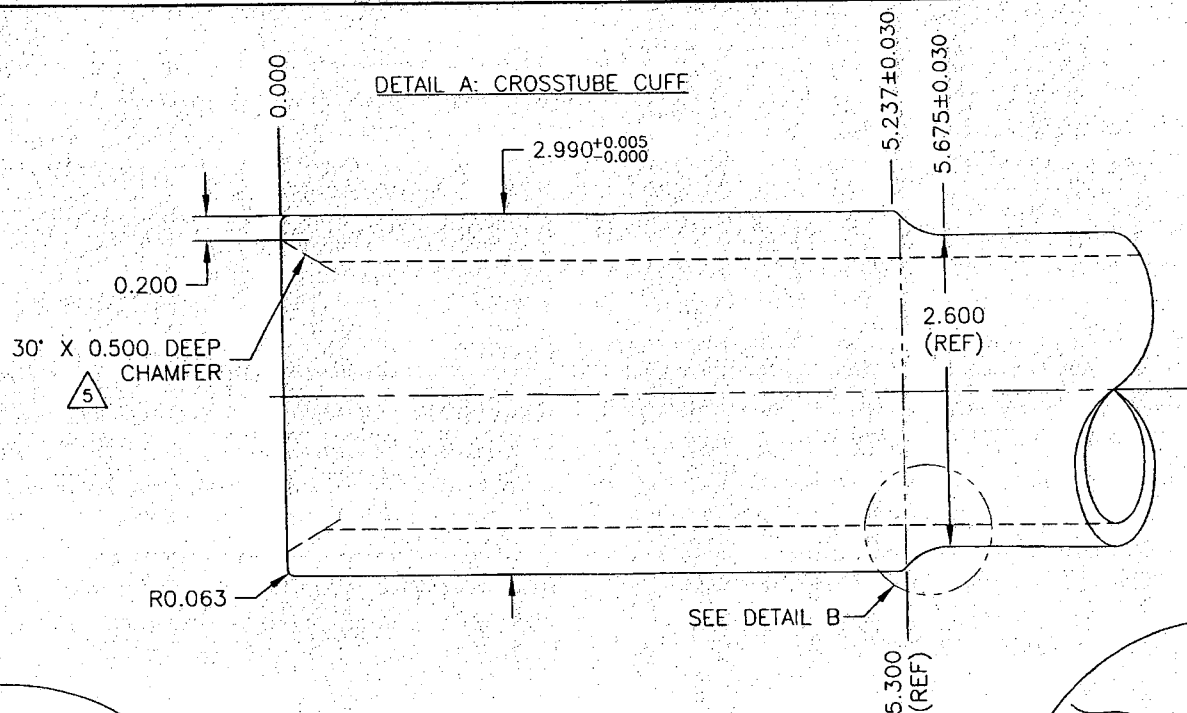
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DESIGN PH	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. D212-664-241	REV. B SHEET 2 OF 3
DATE 05.02.04		TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE 1:10

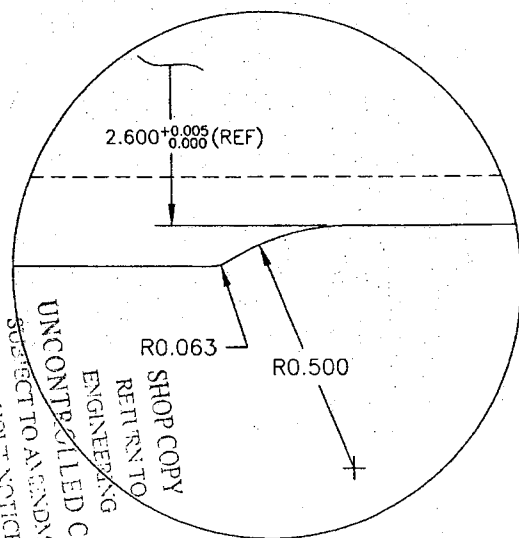
NO. 31360  
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ENGINEERING  
RETURN TO  
SHOP COPY  
WITHOUT NOTICE



RELEASED  
05-06-09

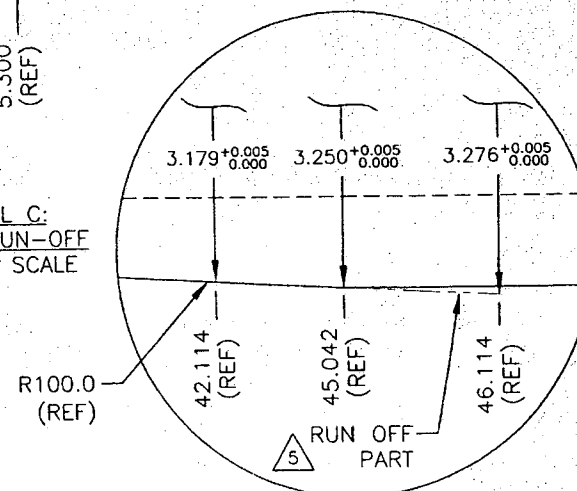


UNDER REVIEW  
07.03.03 PH  
REVISED AND  
# 07.03.20



DETAIL B: CUFF  
TRANSITION  
SCALE 4:1

DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE



NO. 21360  
WEEK ORDER  
3/360  
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DESIGN PH	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. D212-664-241	REV. B SHEET 3 OF 3
DATE 05.02.04	TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE 1:1	

**L Lacelle**

---

**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** April 26, 2007 10:38 AM  
**To:** 'Jason Murdoch'  
**Cc:** 'L Lacelle'  
**Subject:** FW: Drawings  
**Importance:** High  
**Attachments:** Drawing 001.jpg; Drawing 002.jpg; Drawing.jpg

B31360 is acceptable as is.

B31363 is acceptable as is.

With respect to B31040, I agree it is acceptable to move the holes up the cuff and trim the bottom off the cuff, if necessary. Drill holes with jigs pushed right up and check with a saddle for clearance.

David

---

**From:** Jason Murdoch [mailto:jmurdoch@dartaero.com]  
**Sent:** Wednesday, April 25, 2007 9:02 AM  
**To:** 'David Shepherd'  
**Subject:** FW: Drawings  
**Importance:** High

Hi Dave, we have a couple of tubes that are high, and out of my tolerance. The one that concerns me the most is the D407. Can we compensate for the height by drilling up higher on the cuff without interfering with the tube and saddle fit, and maybe remove some of the bottom of the cuff if necessary? The 407 fits not bad at all in the jig, other than being too high, and a tad narrow.

What are your thoughts on the 212's? I think these aren't that bad, just high. The 212's fit good in the table jig. If it's possible, I would like a response today, because I'm leaving for 5 days, thatnks.

[jmurdoch@dartaero.com](mailto:jmurdoch@dartaero.com)

Q.C. COORDINATOR

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**From:** Brigitte Golden [mailto:bgolden@dartaero.com]  
**Sent:** Wednesday, April 25, 2007 10:33 AM  
**To:** 'Jason Murdoch'  
**Subject:** Drawings

Brigitte Golden  
Order Processing  
Dart AerospaceLtd.

26/04/2007



# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36419

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of seven (7) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 338, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (1) P/N D212-664-201 S/N B31360  
Qty. (1) P/N D058-676-101 S/N B30250  
Qty. (2) P/N D206-667-101 S/N's B29101 & B28680  
Qty. (3) P/N D412-664-145 S/N's B31596, B31594 & B31595



RADIOGRAPHY



ULTRASONIC



PENETRANT



MAGNETIC PARTICLE



EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on seven (7) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive) Ardrex 970P25E Batch #04B503.

Five (5) cross tubes PASSED inspection and two (2) cross tubes FAILED inspection (P/N D212-664-201 S/N B31360 & P/N D058-676-101 S/N B30250).

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY: 

DATE May 31, 2007

INSPECTION  
STAMP(S)

Not Required

### CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

3825

ADDRESS:

CONTACT NAME:

AE OUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

@

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT

Date: Monday, 30/04/2007 12:02:02 PM  
User: Linda Lacelle

# **Process Sheet**

<b>Customer</b> : CC-DAR01 Dart Aerospace Ltd.	<b>Drawing Name</b> : D212-664-201
<b>Job Number</b> : 32120	
<b>Estimate Number</b> : 10804	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D212664201
<b>This Issue</b> : 30/04/2007 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : RTN589
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : <i>N/A</i>
<b>First Issue</b> : 30/04/2007 <b>Type</b> : LANDING GEAR	<b>Drawing Revision</b> : <i>N/A</i>
<b>Previous Run</b> : 00015	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 07/05/2007 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	
<b>Comment</b> :	

## **Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	QC5	INSPECT WORK TO CURRENT STEP



**Comment:** INSPECT RTN 589

*07/04/30*

2.0	D212664201	Crosstube Installation
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Crosstube Installation  
ORIGINAL B/N *27988*

*07/04/30*

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

REPACKAGE PER PPP  
USING NEW B/N  
NEW PAPERWORK AND LABLES REQ'D

*REV: C 07/04/30*

4.0	QC21	FINAL INSPECTION/W/O RELEASE
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**Comment:** FINAL INSPECTION/W/O RELEASE

*07/05/01*  
*W 07/05/01*

Job Completion



<b>DART</b>			
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D212-664-201	CHG	CHG002
DESC.	Crosstube Aft High	STC	SH01-9
LOT	B27988	STC	SR01298NY
MODEL	Bell 204/205/212/214	STC	

MADE IN CANADA